

25

Date: Wednesday, 6/6/2007 2:02:51 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WINDOW ASSEMBLY  
 Job Number : 32816B  
 Estimate Number : 10304  
 P.O. Number : *N/A* Part Number : D3136043  
 This Issue : 6/6/2007 S.O. No. : *N/A* Drawing Number : D3136 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : D  
 Previous Run : 32272B Material : *N/A*  
 Due Date : 6/20/2007 Qty: 8 Um: Each  
 Written By :  
 Checked & Approved By : *07/06/07*  
 Comment : Est Rev.A 04.02.04 New issue KJ/DS  
 Est Rev.B 07.05.29 Thermoform in-house DL

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLICS125 1/8" Polycast II Sheet



Comment: Qty.: 3.9000 sf(s)/Unit Total : 31.2000 sf(s)  
 polycast II or plexiglass G .125"

*BH M104596 (2)*

2.0 WATER JET FLOW WATER JET



*(8)*

Comment: FLOW WATER JET

*BH ml 07 06 26*  
*SAD 07/06/24*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



*(8)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



*cauter*

Comment: SECOND CHECK

*En 07/06/24*

5.0 THERMOFORMING THERMOFORMING MACHINE



Comment: 1-Thermoform as per Dwg .D3136 and Folio FTA002

Dwg. Rev *D*  
 Folio Rev. *FTA002*

*07/07/06 BH*

2- Engrave Part # and Batch # , and affix labels

*07/07/06 BH*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 2 Date: 27/07/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 2:02:51 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 32816B

Part Number: D3136043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part# Description Batch

2 D3108-9 Decal

B 22608

07/07/06 Wh.

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



07/07/06 Wh.

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/09 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/07/09 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/09

Job Completion



07/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

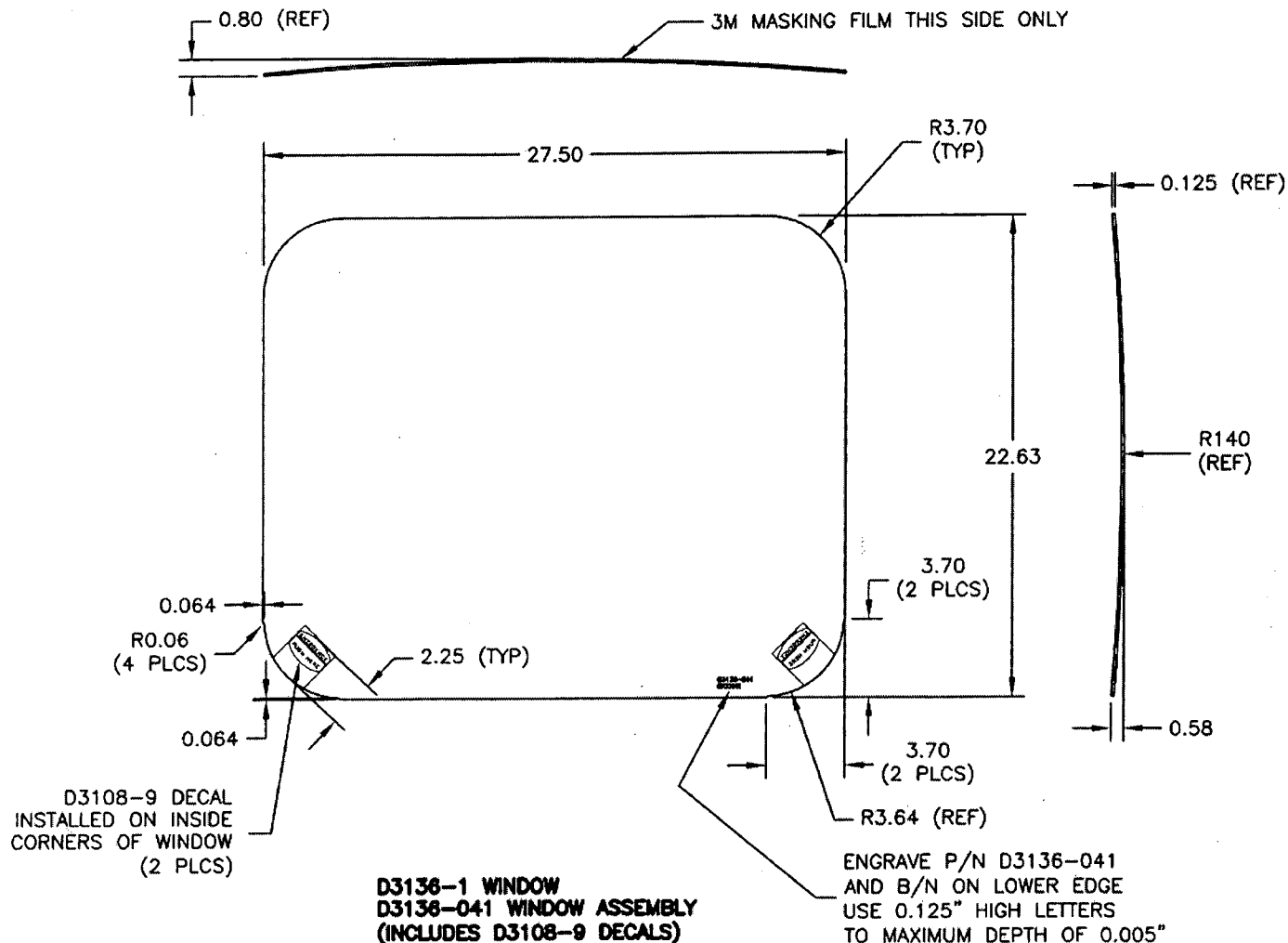
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3136	REV. D SHEET 1 OF 2
DATE 05.12.01		TITLE WINDOW ASSEMBLY	SCALE 1:8
A	02.04.18	NEW ISSUE	
B	04.01.21	ADDED D3136-3 AND D3136-043	
C	04.05.05	ADDED FORMING & ENGRAVING SPEC	
D	05.12.01	UPDATED MATERIAL NOTES	

RELEASED  
05.12.01



**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G  
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

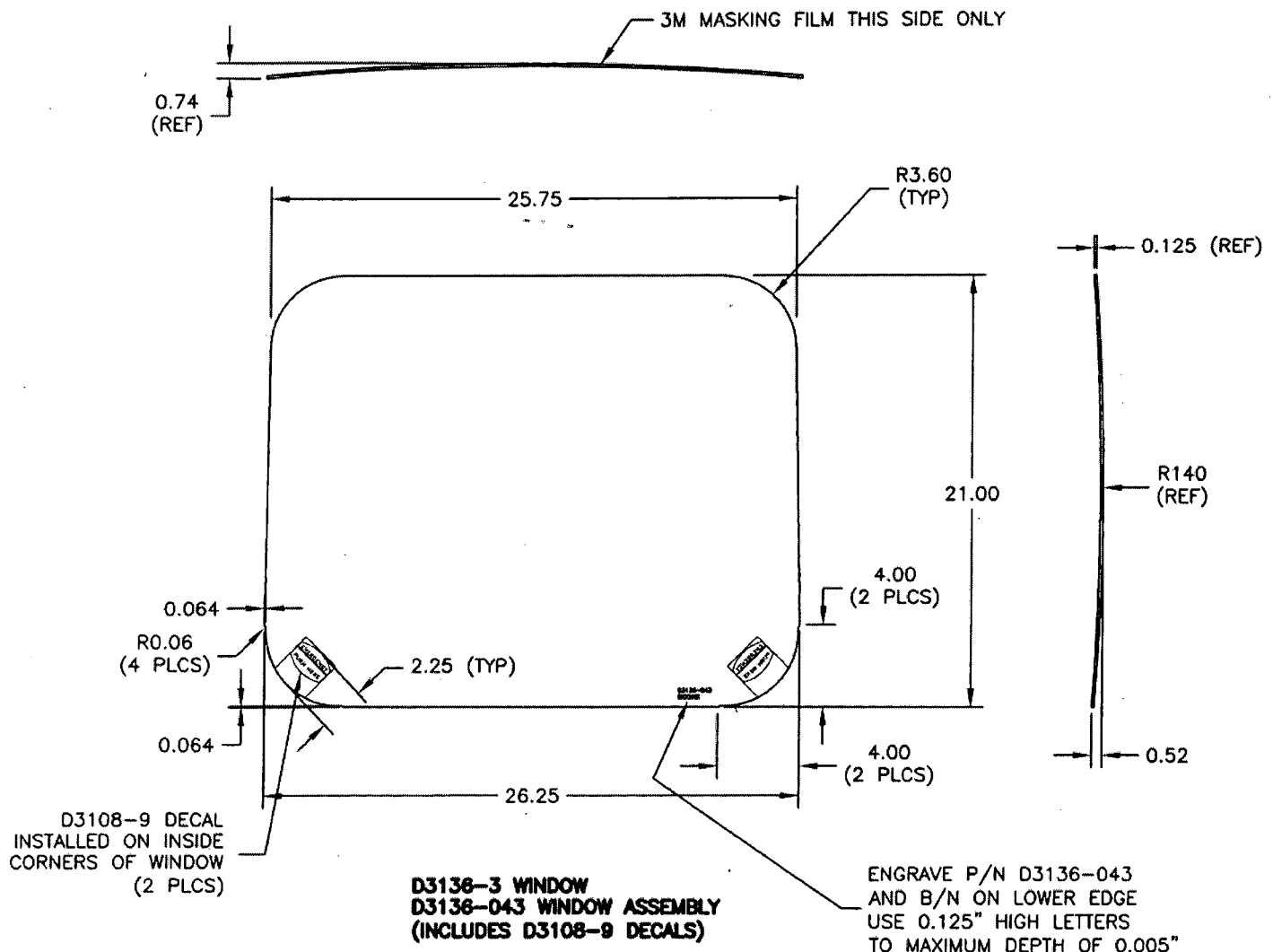
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**DART**

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3136	REV. D SHEET 2 OF 2
DATE 05.12.01		TITLE WINDOW ASSEMBLY	SCALE 1:8

**RELEASED**  
05-12-01 [Signature]**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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